



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3195-043
Job Sheet 169577



Part No: D3195-043

Job Qty: 5 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-08 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		1/4/18	0.00	0.00	Start Up Machining-2		FM 18-1-17
100	Bandsaw	5 pcs		1/4/18	0.00	0.10	Bandsaw1		FM 18-1-17
110	CNC Vertical Machining	5 pcs		1/4/18	0.36	2.75	HAAS1-3		FM 18-1-17
120	QC	5 pcs		1/4/18	0.00	0.00	QC2 Machining-2		FM 18-1-17
130	QC	5 pcs		1/4/18	0.00	0.00	QC8 Machining-2		FR 18-1-18
140	HandFinish	5 pcs		1/4/18	0.00	0.27	HandFinish1		2018/01/18 JSC
150	Powdercoat	5 pcs		1/4/18	0.00	0.15	Powdercoat3		BR 18-1-18
160	QC	5 pcs		1/4/18	0.00	0.00	QC3		38
170	Small Fab	5 pcs		1/5/18	0.00	0.73	Small Fab-3		FF 18-1-18
180	QC	5 pcs		1/5/18	0.00	0.00	QC5		AL 18-1-19
190	Packaging	5 pcs		1/5/18	0.00	0.00	Packaging3-1	57 021	AT 18-1-19
200	QC21-SA	5 Ea		1/5/18	0.00	0.00	QC21		DAS

Part Op 100 - Cut blanks: (1.250" x 1.500") x 3.60" long

Descriptions: 110 - 1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3

150 - START TIME: 8:35 OUT 320° FINISH 4:05

170 - 1-Lightly Sand bonding surface 2-Bond D3195-7 into D3195-13as per Dwg D3195

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3195-7 F159572	5	6	0	0
170-Small Fab	M6061T6B1.500X01.250	2	12	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS S _____ M _____ Thermal _____ L _____ C _____		Engineering ☐ Quality ☐ Other ☐ (SIO42) Approval _____ Completed By _____ and / Supervisor Approval _____ QA Coordinator Approval _____ Conditioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence					
Date : _____		Step #: _____									
Description Work Order Deviation				 Bracket							
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>				Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Temperature ☐ Set-up ☐ BOM/F ☐ Broker ☐ Inspection ☐ Contamination ☐ Count ☐ Cut To ☐ Instrument ☐ Drill Holes ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature ☐ Set-up ☐ BOM/F ☐ Broker ☐ Inspection ☐ Contamination ☐ Count ☐ Cut To ☐ Instrument ☐ Drill Holes ☐
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OTHER : _____											

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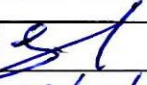
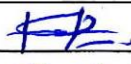
DART
 AEROSPACE
S033168
Bracket

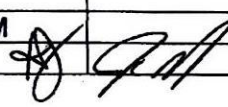
PART NO: D3195-043
Original Serial #: S033168
Revision:
Operation: Start up Operation 01/17/18
Change No: Job No: 169577

DART AEROSPACE LTD		Work Order:	169577
Description: Bracket		Part Number:	D3195-3
Inspection Dwg: D3195	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.433	/			
1.265	+/-0.010	1.264	/			
R0.37	+/-0.030	R0.375	/			
Ø0.277	+0.005/-0.001	0.2775	/			
2.677	+/-0.005	2.675	/			
0.242	+/-0.010	0.245	/			
0.377	+/-0.010	0.377	/			
0.500	+/-0.010	0.499	/			
R0.188	+/-0.010	R0.1875	/			
0.250	+/-0.010	0.258	/			
0.882	+/-0.010	0.889	/			
1.250	+/-0.010	1.250	/			
0.500	+/-0.010	0.498	/			
Ø0.191	+0.005/-0.001	0.192	/			
1.000	+/-0.010	1.001	/			

Measured by: 	Audited by: 	Preliminary Approval:
Date: 18/01/17	Date: 18-1-18	Date:

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	
C	12.05.14	Dwg Rev updated	KJ	



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D3195-043 Revision: Bracket														
200	QC21-SA	S033168	169577	5 Ea	0	S033168	ST021		Stock	1/17/2018	Issue Container			
Operation Totals:		1		5	0									
Part Totals:		1		5	0									
Part Number: M6061T6B1.500X01.250 Revision: 6061-T6 Bar 1.50 X 1.25														
100	Receive Ft	S033130	169577	0 ft	0	m136882	Start Up Machining-2		Stock	1/17/2018	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		5	0									

Plex 1/19/2018 1:23 PM Dart.Lajeunesse.Marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								